

Work Order ID 56796

March 10, 2010 12:35:59 PM



Page 1

Item ID: D212-725-1-203

Accept



Setup Start



Revision ID:

Stop



Item Name: TUBE ASSEMBLY

Start Date: 3/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 3/26/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: CZ

Date: 10/3/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D212-725-1-203	<u>Rev. E</u>

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 11081

Manufacture as per Dwg D212-725-1

- Ship mat'l and parts to vendor

Possible Supplier: Cintube

Material release note required

CZ

10/3/10

4

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Rev 3/26 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56796

March 10, 2010 12:35:59 PM

Page 2

Item ID: D212-725-1-203

Accept

Setup Start

Revision ID:

Stop

Item Name: TUBE ASSEMBLY

Start Date: 3/10/10 Start Qty: 4.00

Cust Item ID:

Required Date: 3/26/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 51382 0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release 0.00

QC

Memo

0.00

Quality Control

(x4)

Pl 10/3/30 (4)

10/03/31 HJ

Pl 10-3-31 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

March 10, 2010 12:35:59 PM

Work Order ID: 56796



Parent Item: D212-725-1-203



Parent Item Name: TUBE ASSEMBLY

Start Date: 3/10/10

Required Date: 3/26/10

Comments: IPP Rev:A new issue DD 10.03.10 verified by:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN818-8J		Purchased	No			100	Each	19.0000	4.0000			



Nut

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

106074

107959

100

f

146.6580

16.8421

M304TR0.500W.035

Purchased

No



304 RD Tube .500 x .035W

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

108250

111704

112187

112800

146.6579674

2.23

31.6682737

40.0630937

72.6966

~~112187 x 5.4~~
~~112800~~ 12.084
~~112800~~

1810-3-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 10, 2010 12:35:59 PM

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Parent Item: D212-725-1-203



Parent Item Name: TUBE ASSEMBLY


Start Date: 3/10/10

Required Date: 3/26/10

Comments: IPP Rev:A new issue DD 10.03.10 verified by:EC

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Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20819-8J  Sleeve		Purchased	No			100	Each	37.0000	4.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST323

17

112082

17

Main Warehouse

t

20

112933

20

D212-725-1-203P

Purchased

No

110

Each

0.0000

4.0000



TUBE ASSEMBLY

4 C2101311

4 B 56796

BP

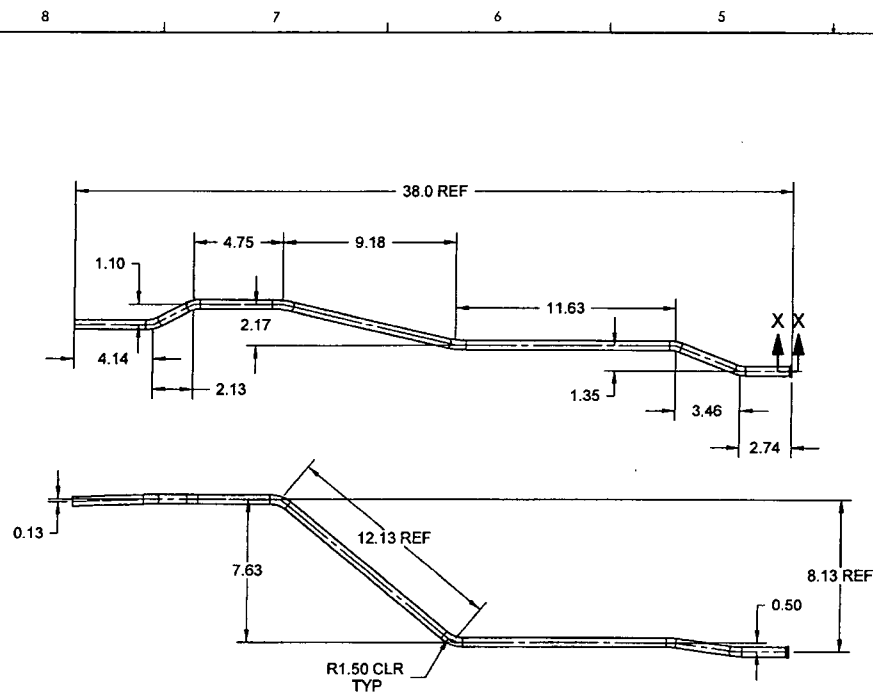
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

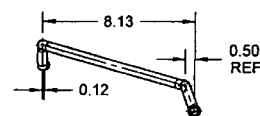
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

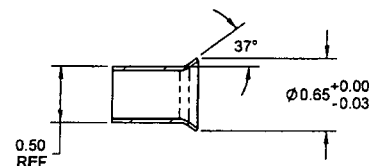
NOTE: Date & initial all entries



D212-725-1-203 TUBING
(MANUFACTURE PER TEMPLATE DT8916)



SECTION X-X
(FINISH FLARE THIS
END AFTER ASSEMBLY)
SCALE 5X



D212-725-1-935 TUBE ASSEMBLY

D212-725-1-203
TUBING

AN818-8J NUT (1)
MS20819-8J SLEEVE (1)

NOTES:

- 1) MATERIAL: AISI 304/316 SS Ø0.50 x 0.035 WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.500W.035)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY B/N & P/N D212-725-1-935 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DS	DRAWING NO.	REV. E
MFG. APPR.	N/A	D212-725-1	SHEET 88 OF 82
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	08.09.17	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
R 2009-10-28

56996



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO11081

Purchase Order Date 1/11/10

PO Print Date 3/12/10

Page Number 1 of 1

Order From :

VC-CIN001

CINTUBE LTEE
333 ST-JOSEPH BLVD
LACHINE, QC H8S 2K9
CA

REVISED \$

Contact Name
Vendor Phone 514 634 3592
Vendor Fax 514 636 3336
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4003-049P	TANK VENT LINE ASSEMBLY	3/26/10 Yes	2.00 Each	Purolator ground	\$175.0000	\$350.00
Special Inst:			AS PER DWG D4003 REV. A-PRELIM B55194 AS PER QUOTATION : #2009-36163 MATERIAL & NUT/SLEEVE WILL BE SHIP TO CINTUBE				
2	D212-725-1-203P	TUBE ASSEMBLY	3/26/10 Yes	4.00 Each	Purolator ground	\$180.0000	\$720.00
Special Inst:			AS PER DWG D212-725-1-203 REV. E B56796 AS PER QUOTATION: #2010-37009 MATERIAL & NUT/SLEEVE WILL BE SHIP AT CINTUBE				

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

PO Total: \$1,070.00

Change Nbr: 4

Change Date: 3/12/10

CZ

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required when applicable

CLIENT: Page 1 of 1
DART AEROSPACE LTD.
1270 ABERDEEN ST.

HAWKSURRY
ON K6A 1K7
EXPED. A/TO :
SAME

M-108242

CINTUBE LTEE/LTD

☒ 333 BOUL. ST-JOSEPH, BUILDING # 105
LACHINE, QUEBEC
H8S 2K9
TEL: (514) 634-3592
FAX: (514) 636-3336 / 8625

☐ 1250 MATHESON BLVD. EAST
MISSISSAUGA, ONTARIO
L4W 1R2
TEL: (905) 625-190
FAX: (905) 625-1500

BON. LIVR.:	RELACHE
PACK. SLIP	M-108242
ORDER #:	12-Mar-10
COMMANDE #:	PO11081

Rep: PATRICK ZALATAN

CLIENT NO.	MAT'L PAR / MAT'L BY	REFERENCE	MODE DE PAIEMENT / TERMS OF PAYMENT					
MDAR72	CLIENT		1.5 % - 10 DAYS / NET 30					
TRANSPORT		DATE LIV. / DELIV. DATE	CONTACT					
PUROLATOR COLLECT #7684382		10 A/TO 12 JOURS/DAYS	CHANTAL LAVOIE					
QUANT	EXP.	DIMENSION / SIZE	EP / WALL	DESCRIP. MAT'L / MAT'L DESCRIP.	DEG.	RAY. / RAD.	TANGENTE / TANGENT	INSTRUCTIONS
4	4	0.5 OD	0.035	PART NO. DART D212-725-1 SMLS TUBE SS/304L	6 BENDS	1.5	SEE DRWG: D212-725-1	FINAL CUT & FLARE ONE END
2	2	0.5 OD	0.035	PART NO. DART D4003-9 TUBE ALUMINIUM	MULTIPLE BENDS	1.77 CLR	SEE DRWG: D4003-9	FINAL CUT & FLARE
1	1			NUTS & SLEEVES BY DART LETTRE DE CONFORMITE				

80603/29

Notes:

CATEGORIE ISO	1	2	3
ISO CATEGORY	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
ASME	<input type="checkbox"/>		

LETTRE DE CONFORMITE
LETTER OF COMPLIANCE

OUI
YES ☒

EXPEDIE PAR / SHIPPED BY:

DATE CLIENT AVIS / ADV.:

DATE:

CONTACT:

CLIENT: X

PAR/BY:

DATE:

CINTRAGE DE PRÉCISION. DE TUBES, TUYAUX, CORNIÈRES, POUTRES,
PROFILÉS EN "U", ET SERPENTINS.
MANUFACTURIER DE GÉNÉRATRICE À VAPEUR, ÉLÉMENT CHAUFFANT,
RÉCUPÉRATEUR DE CHALEUR, ÉCONOMISEUR ETC.
PRECISION BENDING OF TUBES, PIPES, ANGLES, BEAMS, CHANNELS, COILS.
MANUFACTURERS OF STEAM GENERATORS, THERMAL FLUID HEATERS,
WASTE HEAT RECOVERY UNITS, ECONOMIZERS.

333 BOUL. ST-JOSEPH, LACHINE, QUÉBEC H8S 1
TÉLÉPHONE: (514) 364-6426 FAX NO: (514) 636-3

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Client/Customer DART AEROSPACE LTD

Date: MARCH 24/2010

N° de commande du client/Customer order No: PO11081

Notre n° de feuille de route/Our order No: 108242

Notre n° de dessin/Our drawing No: _____

Description/Customer drawing No: D212-725-1 S68, D4003-9

Nom de la piece/Part Name: D212-725-1-203 = 4 pcs

D4003-9 = 20cs

8/10/03/27

La présente est pour certifier que le matériel ci-haut mentionné se conforme aux exigences contractuelles de qualité et/ou de la confirmation de la commande, qu'il a été produit, inspecté et testé selon les spécifications standards applicables de notre programme de contrôle de la qualité, du contrat et du(des) dessin(s).

This is to certify that the material covered by this document conforms to the quality requirements of the purchase order or contract, that the material has been produced, verified and tested according to applicable standard specifications listed in our quality control procedures, contract specifications and/or drawing(s).

Signé par/Signed by: _____

G. HOULE pour B. OVERBURY

Directeur des services techniques/Technical Services Director

Pour la Compagnie Cintube Ltée/On behalf of Cintube Ltd.